

Date: Thursday, 12/14/2006 10:20:10 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: SMALL ENGINE MOUNTS
Job Number	: 00098A		
Estimate Number	: 10068		
P.O. Number	:	Part Number	: INITIAL PROTOTYPE
This Issue	: 12/14/2006 S.O. No. :	Drawing Number	: D212-725-1 -- 109 / -110
Prsht Rev.	: NC	Project Number	: ES0001
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: REV A
Previous Run	: 00097A	Material	:
Written By	: <u>JA 06-12-14</u>	Due Date	: 12/21/2006
Checked & Approved By	:	Qty:	2 (-110)
Comment	: Project #: Eagle "S"	Um:	Each
	Description: Small Engine Mount		(-109)

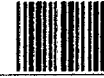
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140NB1500X15000	AISI 4140 Steel Bar
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Comment: Qty.: 1.3003 f(s)/Unit Total : 1.3003 f(s)

AISI 4140 Steel Bar

Batch": 102949

JA 06-12-13 (2+2)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA657 and Dwg D212-725-1

JA 06-12-13 (2+2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA 06-12-13 (2+2)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JA 06-12-14 (2+2)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/A

Job Completion



ENGINEERING PROJECT MANAGER
 APPROVAL

JA 06-12-21

Level 2 Inspection JA 06-12-22

8

7

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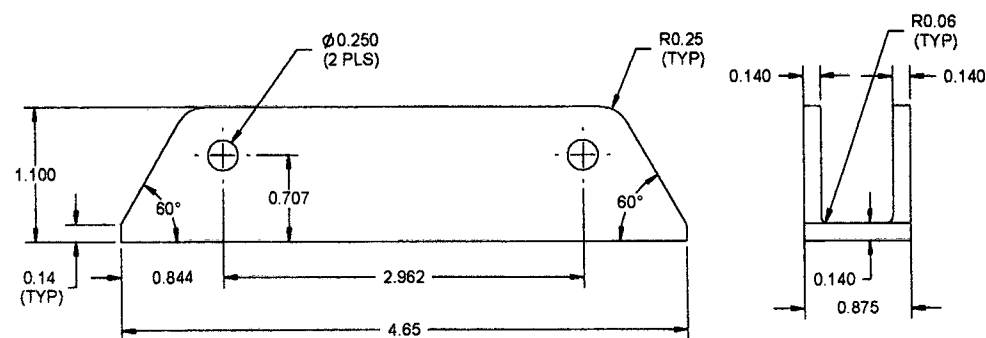
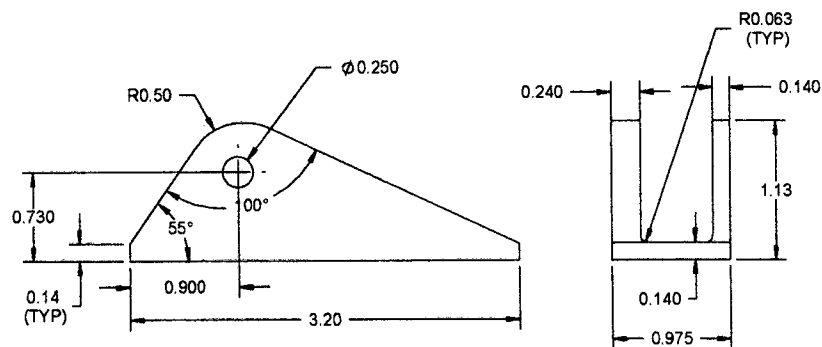
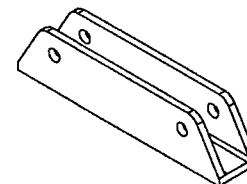
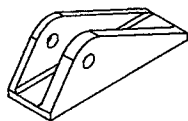
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D212-725-1-109 SMALL ENGINE MOUNT
D212-725-1-110 OPPOSITE

D212-725-1-111 LARGE ENGINE MOUNT

D212-725-1-109/-110/-111 NOTES:

- 1) MATERIAL: AISI 4140/4130 STEEL BAR PER MIL-S-5626/-6758 OR AMS 6382/6349/6529 OR AMS 6348/6370/6528 (REF. DART SPEC. M4140N-B OR M4130N-B) HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN JL	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A
DATE 06.11.20		TITLE 212S DETAIL PARTS	SCALE 1:1
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02/12/2006

Heat Number Chemical Analysis

Amber 10000
0.440
0.900
0.250
0.021
0.055
1.000
0.000

- MO
- ✓
- NI
230
082
170

London 2053
Grade 414
Country USA

Brinell 302
Mill

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY

ON

K6A 1

**YOUR PURCHASE
ORDER NUMBER**

P000002606

Today's Date: 12/12/06

MCMASTER-CARR
200 AURORA INDUSTRIAL PKWY
AURORA OH 44202

IF THERE ARE ANY QUESTIONS ABOUT THIS
SHIPMENT CONTACT OUR SALES DEPARTMENT
(330)995-5500

PAGE

1

MCM NUMBER

6536977-01

(CALLER) C LAVOIE

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
	9116 K999	1 EA	4140 ALLOY STEEL HARDENED RECTANGULAR BAR 1-1/2" TK X 1-1/2" WD X 6 FT LENGTH WITH MILL TEST REPORTS	1 ✓	1 EA	1

725-1-102/110

☒ First Article ☐ Prototype

Material: 4140 NORMALIZED
Batch: 102949

~~11~~
06.12.21

Revised by	Approved
KJ/RF	